



Description: SN: S089688

Ship Via:

Bill of Materials

 $\frac{1}{4}$

Job Routing									
Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		10/26/18	0.00	0.00	Start Up Skidtubes-1		MGG
100	Skidtubes	1 pcs		10/26/18	0.00	0.00	Skidtubes-1		MGG
227	HandFinish	1 pcs		10/26/18	0.00	1.05	HandFinish2		NA
240	SprayPaint	1 pcs		10/26/18	0.00	0.56	Spray Paint		
245	QC	1 pcs		10/26/18	0.00	0.00	QC14		
250	HandFinish	1 pcs		10/26/18	0.00	1.05	HandFinish4		
260	QC	1 pcs		10/26/18	0.00	0.00	QC5		
270	HandFinish	1 pcs		10/26/18	0.00	1.49	HandFinish4		NA
280	QC	1 pcs		10/26/18	0.00	0.00	QC5		
285	HandFinish	1 pcs		10/26/18	0.00	1.05	HandFinish3		M 12-10-2018
286	QC	1 pcs		10/26/18	0.00	0.00	QC5		OCT 25 2018 68
288	DC	1 pcs		10/26/18	0.00	0.00	DC		21 9:59
290	Packaging	1 pcs		10/26/18	0.00	0.00	Packaging3-1		NOV 0 2018
300	QC21-FG	1 Ea		10/26/18	0.00	0.00	QC21		NOV 0 1 2019

Part Op 100 - Drill holes as per DSI 9734 Rev. D - DO NOT INSTALL CROSSBOLT SPACERS
 Descriptions: 227 - Pressure Wash per QSI005 4.3

240 - Spray Painting per QSI005 4.2 *****AS PER DEO DETAIL "F" NOTE 8, SHEET 8 MASK THIS AREA, DO NOT APPLY PRIMER OR PAINT***** PRIME AS PER DWG AND QSI 005 4.2 BATCH: _____ PAINT WHITE AS PER DWG AND QSI 005 4.2 BATCH: _____

245 - QC14- Inspect Spray Paint

250 - Assemble as per dwg 1-Install inserts as per Dwg D3905.

260 - QC5- Inspect part completeness to step on W/O

270 - 1-Install wearpads, gaskets and wearplates as per Dwg D3905. Put sikaflex in insert before installing bolts and washers A/R Sikaflex-240/-291 M138943 Sikaflex expire date: 19-03 2- install plugs assembly as per dwg. 3 -Inspect for foreign objects as per QSI 024 4 -Install D2855-3 Cap and seal with Sikaflex. Clean excess adhesive. A/R Sikaflex-240/-291 M138947 Sikaflex expire date: 19-03 5 -Install insert in D2855- Cap. Install cap and seal with Sikaflex. Clean excess adhesive. A/R Sikaflex-240/-291 M138947 Sikaflex expire date: 19-03

6- Install (2)D5101-041 and (1) D5101-047 as per dwg by using DT10117

280 - QC5- Inspect part completeness to step on W/O

285 - Wing Walk as per dwg QSI005 4.4 Batch 5082120

286 - QC5- Inspect part completeness to step on W/O

288 - Document Control Photocopy bluefile & type labels per PPP D119-646-243 CHG 005

290 - Identify as per dwg & Stock Location: _____

300 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D119-646-243	AW119 Repl. Skidtube with Heavy Duty Wearplates, Float Compatible -Fits LH or RH	1 Ea (1 ea)	90-Start up Operation	
ALS4-1032-130	Rivnut	10 Ea (10 ea)	250-HandFinish	
ALS4-1032-225	Rivnut	1 Ea (1 ea)	270-HandFinish	
AN3C46A	Bolt	4 Ea (4 ea)	270-HandFinish	
AN3C50A	Bolt	4 Ea (4 ea)	270-HandFinish	
AN3C5A	Bolt	12 Ea (12 ea)	270-HandFinish	
AN4C46A	Bolt	3 Ea (3 ea)	270-HandFinish	
D2855-3	Cap	1 Ea (1 ea)	270-HandFinish	
D3411-3	Washer	16 Ea (16 ea)	270-HandFinish	
D3672-1	Washer, Phenolic	2 Ea (2 ea)	270-HandFinish	
D3847-1	Wearpad	1 Ea (1 ea)	270-HandFinish	
D3847-11	Wearpad	1 Ea (1 ea)	270-HandFinish	
D3849-045	Aft Heavy-Duty Wearplate, Float Skid Compatible	1 Ea (1 ea)	270-HandFinish	
D3849-047	Fwd Heavy-Duty Wearplate, Float Skid Compatible	1 Ea (1 ea)	270-HandFinish	
D3904-1	Washer	16 Ea (16 ea)	270-HandFinish	
D5101-041	Crossbolt Spacer Assembly	2 Ea (2 ea)	270-HandFinish	
D5101-047	Crossbolt Spacer Assembly	1 Ea (1 ea)	270-HandFinish	
D5101-3	Insert	6 Ea (6 ea)	270-HandFinish	
D5101-5	Insert	6 Ea (6 ea)	270-HandFinish	
MS21043-3	Nut	8 Ea (8 ea)	270-HandFinish	
MS21043-4	Nut	3 Ea (3 ea)	270-HandFinish	
MS24694-C52	Screw	2 Ea (2 ea)	270-HandFinish	
NAS1149C0332R	Washer	8 Ea (8 ea)	270-HandFinish	
NAS1149D0416J	Washer	3 Ea (3 ea)	270-HandFinish	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D119-646-243	1	0	0
250-HandFinish	ALS4-1032-130	10	11,813	0
270-HandFinish	ALS4-1032-225	1	1,815	0
	AN3C46A	4	92	0
	AN3C50A	4	189	0
	AN3C5A	12	1,694	0
	AN4C46A	3	210	0
	D2855-3	1	4	0
	D3411-3	16	42	0
	D3672-1	2	956	0
	D3847-1	1	34	0
	D3847-11	1	12	0
	D3849-045	1	2	0
	D3849-047	1	1	0
	D3904-1	16	56	0
	D5101-041	2	2	0
	D5101-047	1	4	0
	D5101-3	6	9	0
	D5101-5	6	6	0
	MS21043-3	8	1,175	0
	MS21043-4	3	1,106	0
	MS24694-C52	2	134	0
	NAS1149C0332R	8	3,710	0
	NAS1149D0416J	3	2,275	0

Part Specifications

Specifications could not be found.

Plex 10/19/18 11:15 AM Dart.Gagnon.Michelle

Inspection Sheet Complete RA438

Customer QA Ref #

0

Part Number	Original Batch / Serial # / Ctrl #	Original Revision #	Quantity	Part Complete	Rev/CHG Current	New Paperwork	New Labels	Disposition	Original Container #	New (Receiving) Serial #	New Job #	Work order Instructions
D119-646-243	S095015		1	☒ yes	☒ yes	☒ yes	☒ yes	CUSTOMER SUPPLIED	S095015	S119093		Customer returning D119-646-243 S095015 at Dart to drill holes for hoist guard. During receiving inspection, paint damage on tube was notice. Additional rework to deliver tube back to the customer will be needed as followed • Scuff aft section of tube and re paint (apply Alodine and primer if necessary) • Scuff and re paint aft cap. • Apply wing walk as per drawing. • Replace used hardware. Return to customer using original serial number at CHG005 Add new labels and paper work.
D119-646-243	S089688		1	☒ yes	☒ yes	☒ yes	☒ yes	CUSTOMER SUPPLIED	S089688	S119094		Customer returning D119-646-243 S089688 at Dart to drill holes for hoist guard. During receiving inspection, paint damage on tube was notice. Additional rework to deliver tube back to the customer will be needed as followed • Scuff aft section of tube and re paint (apply Alodine and primer if necessary) • Scuff and re paint aft cap. • Apply wing walk as per drawing. • Replace used hardware. Return to customer using original serial number at CHG005 Add new labels and paper work.
0			0	☐ yes	☐ yes	☐ yes	☐ yes					
0			0	☐ yes	☐ yes	☐ yes	☐ yes					
0			0	☐ yes	☐ yes	☐ yes	☐ yes					
0			0	☐ yes	☐ yes	☐ yes	☐ yes					

QC Approval: AT

Date: 17-Oct-18

Special Return/Rework Instructions:

